

Date: Sunday, 12/4/2005 12:45:08 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP LEG		
Job Number	: 25089B		Part Number	: D2278		
Estimate Number	: 10353		Drawing Number	: D2278 REV D		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	12/4/2005	S.O. No. : N/A	Drawing Revision	: D		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 12/12/2005		
Previous Run	: 24533B		Qty:	40	Um:	Each
Written By	: See Comment below					
Checked & Approved By	: See Comment below					
Comment	: Est Rev:A New Issue 05-11-07 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S080	5052-H32 .080 Sheet	
<p>Comment: Qty.: 1.0306 sf(s)/Unit Total : 41.2230 sf(s) Material: 5052-H32 sheet (QQ-A-250/8) 0.080" Thick (M5052H32S.080) Identify as D2278 Batch: M19052</p>			
2.0	SHEAR	SHEAR J.L	
<p>Comment: SHEAR Cut blanks: (16.61" x 8.51") +.000/-0.020" (grain along 8.51") for each leg</p>			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 J.L	
<p>Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per folio D2278, use stack of 10</p>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE J.L	
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p>			
5.0	QC8	SECOND CHECK	
<p>Comment: SECOND CHECK</p>			

W/O: 00000000000000000000000000000000

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 05/02/24

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD 118112/05/40

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 118112/05/40

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

205-12-19

40

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SAD 05/12/19

40

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

54C 05/12/21 (40)

54C 05/12/21

40

Job Completion

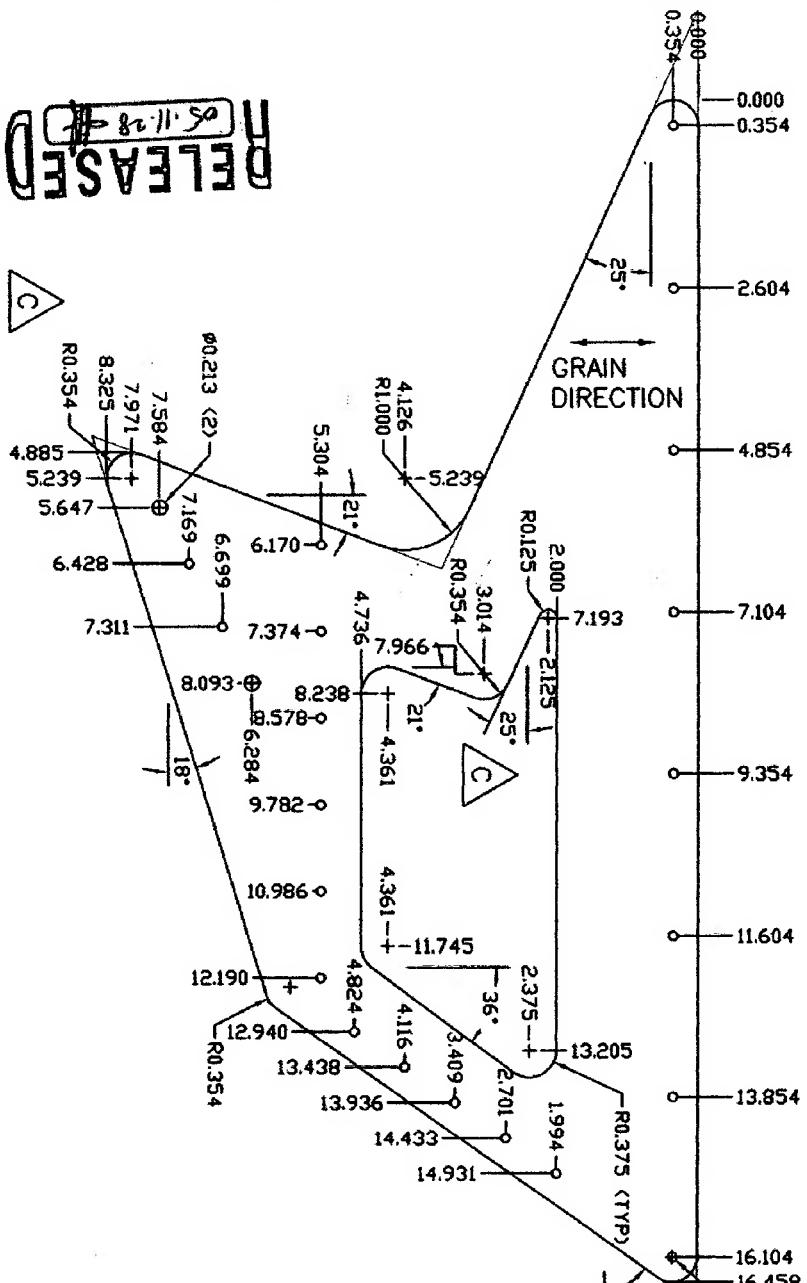


W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Chief Eng	Description Chief Eng			

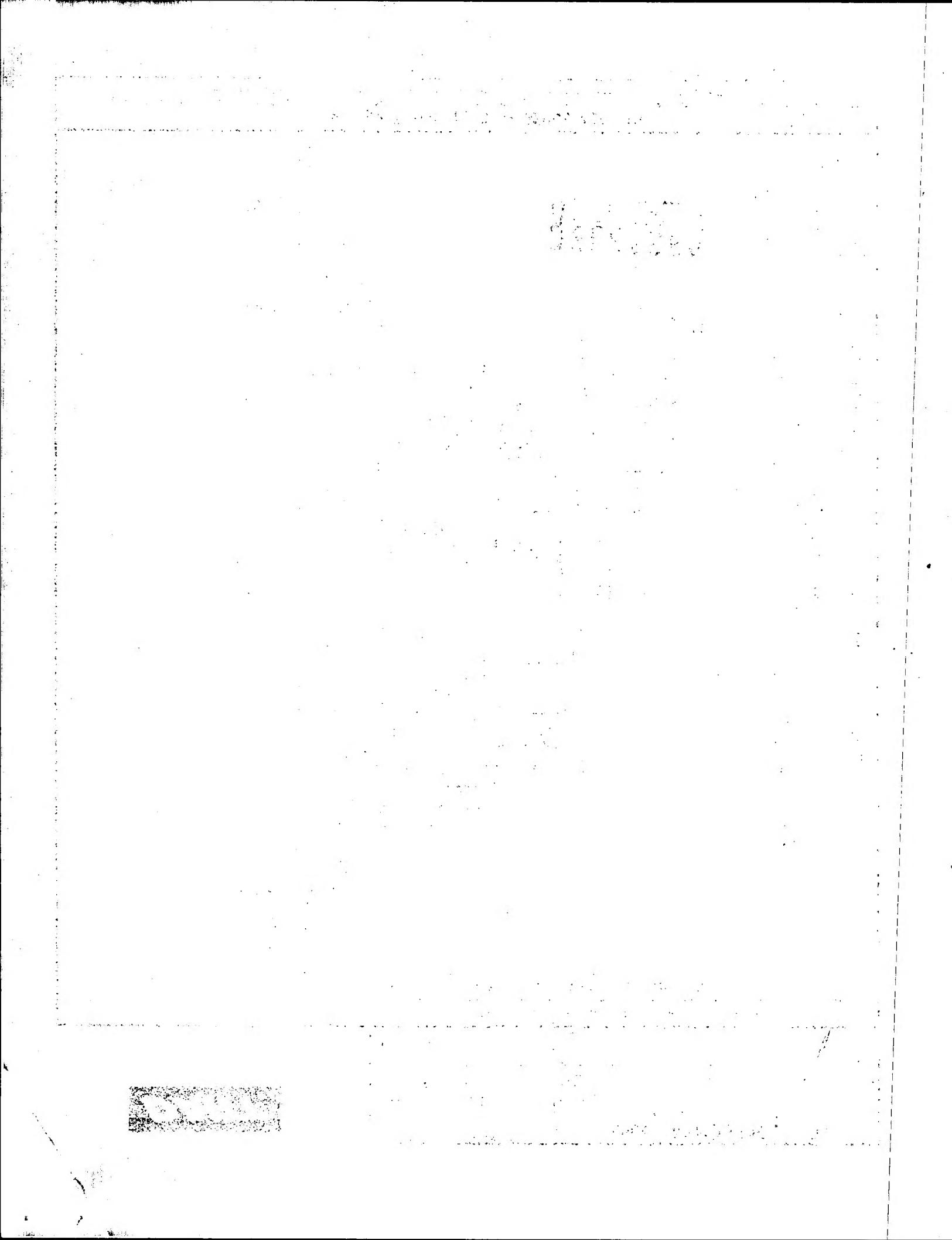
NOTE: Date & initial all entries



D2278 LEG

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET (QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN BY	DRAWN BY	APPROVED BY	DATE	TIME	SCALE
BW	PB	DK	D2278	05.11.98	1:2.5
HAWKESBURY, ONTARIO, CANADA	REV. D	SHEET 1 OF 1	DRAWING NO.	05.11.14	0.354
CHECKED BY	APPROVED BY	DATE	TIME	SCALE	NOTE



DART AEROSPACE LTD	Work Order:	
Description: Leg	Part Number:	D2278
Inspection Dwg: D2278	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L	Audited by:	<i>JL</i>	Prototype Approval:	N/A
Date:	05.12.10	Date:	<i>05/12/10</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	

